Work Order I Wednesday, December	D 64555 er 08, 2010 10:24:10 A										Page 1
	plate /2010 Start Qty: 5.00	,)	Accept	Cust Item			III S	Setup	Start Stop		11 11 11 11 11 11 11 11 11 11 11 11 11
Required Date: 12/2. Reference:	2/2010 Req'd Qty: 5.00			Customer:							
Approvals: Pro	cess Plan:	Date:/ <i>O/2- 8</i> Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3315	Rev B										
Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as if necess	per Dwg D □Dwg Rev:	0.00 0.00 □Prog Rev: 1	□2-Deburr			BIC	<u>-()</u>	- 93	<u>G</u>	
110 QC Quality Control	QC2- Inspect parts o Memo	ff machine FAI/FAIB	0.00				(B.	10-17	56 - C	3	Pto .
120 QC Quality Control	QC8- Inspect parts -	second check	0.00	2/23			46)		-	

W/O: 62	4555	WORK ORDER CHA	ANGES					
DATE	STEP	PROCEDURE CHANGE	PROCEDURE CHANGE By D		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/12/23	120	took aty +1 For ac inspection template	8	10/12/23	H		5 10112	
			J. S.					

Part No: <u>D 33/5-2</u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section E	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto					
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					-								

Work O	rder	ID	6455
Wednesday,	Decem	ber 08	, 2010



Page 2

Item Name: Wearplate Stop	
Start Date: 12/8/2010 Start Qty: 5.00 Cust Item ID: Required Date: 12/22/2010 Req'd Qty: 5.00 Customer: Reference:	
Approvals: Process Plan: Date: Tooling: Date:	
QC: Date: SPC (Y/N): Date:	
Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description Run Hours Code Qty Qty Number	Insp. Stamp
130 0.00	
Small Fab Memo Deburr if necessary N/A	
140 0.00 NC BRAKE	
NC BRAKE Brake NC Memo 0.00	
Brake NC Memo 1- Form using DT8751 Die as per Dwg D3315Rev: Brake NC DT8179 Die and form joggle using DT8157 as per Dwg D3315 Rev: Brake NC	
QC6- Inspect dimensions to drawing QC6- Inspect dimensions to drawing QC6- Inspect dimensions to drawing QC6- Inspect dimensions to drawing	
QC Memo 0.00 Quality Control	

W/O:				ORK ORDER CHANGES							
DATE	STEP	PROCI	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								Prod Wgr			
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	Resolution:										
NCR:		W	ORK OR	DER NON-CONFORMANO	CE (NCF	(1)					
DATE	OTED	Description of NC	Corrective Action Section B Initial Action Description			Verifi	cation	Approval	Approval		
DATE	STEP	Section A		Action Description Chief Eng	Sign of Date	& Sect	ion C	Chief Eng	QC Inspector		
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				24744							
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Work Or	der ID	64555
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Wednesday, December 08, 2010 10:24:10 A



Page 3

Item ID:

D3315-2

Accept



Setup Start



Revision ID:

Item Name:

Wearplate

Start Date:

Required Date: 12/22/2010

12/8/2010

Start Qty: 5.00

Req'd Qty: 5.00



Cust Item ID:

Customer:

Tool ID

Reference:

	_	
An	provals:	
, 10	provats.	

Process Plan: _____

Date:_____

Tooling:

Date: ____

Tool # Plan

Code

Run

Start

Stop



____ Date:

SPC (Y/N):

0.00

0.00

Set Up/

Run Hours

Date:

Accept

Qty

Reject Qty

EZ _ 11-1-11

Reject Insp. Number Stamp

Work Center ID

160

Sequence ID/

Large Fab Large Fab

Large Fab

Operation

Description

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev:

□Qty Part Number Description Batch□A/R

N/A

Memo

Memo

Memo

7560 Hardcoat Rod

170

Quality Control

QC10- Inspect visual per QSI004- ground welds

6000 Dulalia

180

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00 Sulviliz

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W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 64555

Wednesday, December 08, 2010 10:24:10 A



Page 4

Item ID:

D3315-2

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Wearplate

12/8/2010

Start Qty: 5.00

Required Date: 12/22/2010

Req'd Qty: 5.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Code

Tool # Plan

Start

Stop

Reject

L BR 11-0-13.

Reject

Qty

Run

Accept

Qty

Stop



Number Stamp

Insp.

Sequence ID/ **Work Center ID**

190

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4,3,5.6) per QSI005 4.3

Memo

Memo

0.00 0.00

BOYEN_TEMPERATURE:

200

Quality Control

QC3- Inspect Part Finish

0.00

0.00

210

Packaging

Packaging

Packaging

Memo

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-2, B/N: BXXXXX□For Product Eligibility see PDA04-17□and Stock□Location:

0.00

0.00

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W/O:			WO	RK ORDER CHANG	ES	******				
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	Re	esolution:	Disposition	Disposition: QA: N/C Closed: Date: _						
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section B				cation	Approval	Approval
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Work Order ID 64555 Wednesday, December 08, 2010 10:24:10 A												Page 5	
Item ID: Revision ID: Item Name:	D3315-2 Wearplate			* Q1 4x	Accept					Setuj	p Star Stop		
Start Date: Required Date: Reference:	12/8/2010	Start Qty: 5.00 Req'd Qty: 5.00				Cust Item I Customer:	ID:					11881118)	
Approvals:	Process Pla	n:	_ Date: _ _ Date: _		Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Acce Oty	-	eject ty	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

a .

220

Quality Control

de Qty Qty Number Sta

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W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Wednesday, December 08, 2010 10:24:14 AM

Work Order ID: 64555

Parent Item:

D3315-2

Parent Item Name: V. earplate



Sart Date: 12/8/2010

Required Date: 12/22/2010

Page 1

Start Qty: 5.00

Required Qty: 5.00

B10-12-27

Comments:

IPP: $A \square 05.05.12 \square \text{New issue} \square \text{KJ/JLM} \square$

IPP Rev:B As per Rev B 06-03-24 JLM

IPP RevC now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA	TID TIKIN GARK INI ING	Purchased	No			100	sf	84.5250	1.695	8.475			
										IR.	10-12-	46	

1010/1025 sheet 16GA

Location Loc Qty Loc Code MAT19 84.525

111410 84.525 111410

D a. (7 ()	oopaoo								1
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	,
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DART ALROSPACE LTD	Work Order:	44555
Description: Wearplate	Part Number:	D3315-2
Inspection Dwg: D3315 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimens ⁱ on	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	2674-452	×		UB02	
4.402	+/-0.010	4,400	Ø	·	V	
4.137	+/-0.010	4.137	>		V	
3.550	+/-0.010	3,557	2		V	
5.464	+/-0.010	5,466	2		V	
5.214	+/-0.010		يإ		J	
1.224	+/-0.010	1,224	p		J	
2.57	+/-0.030	2.566	2		J	
6.273	+/-0.010	6.266	Ŋ		V	·
8.224	+/-0.010	8.274	2		TBO	
9.515	+/-0.010	9.815	ス		7	s-
11.429	+/-0.010	11.439	×		T	
15.474	+/-0.010	15.474	Ŋ		7	
16.379	+/-0.010	16.379	<u>ን</u>		Τ	
21.360	+/-0.010		R		†	
23.474	+/-0.010	23.474	9		1	
26.273	+/-0.010		>		7	
29.42	+/-0.030		*		7	
0.060	+/-0.010		B		V	
Ø0.300	+0.006/-0.001	306	3		V	

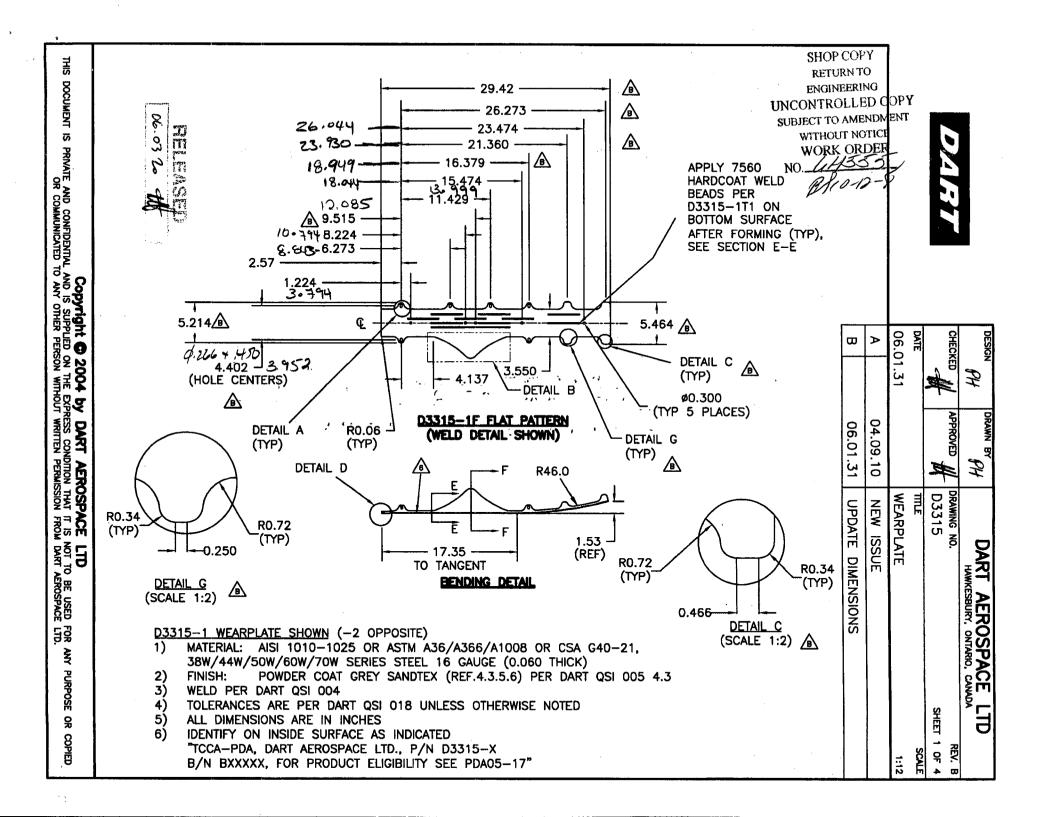
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10-13-32	Date: 10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.09.28	New Issue	KJ	AL.

Dail MCIUSDACE LI	Aerospace Ltd	art Aerospac
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DRAWING NO.

SHEET

SCALE 4

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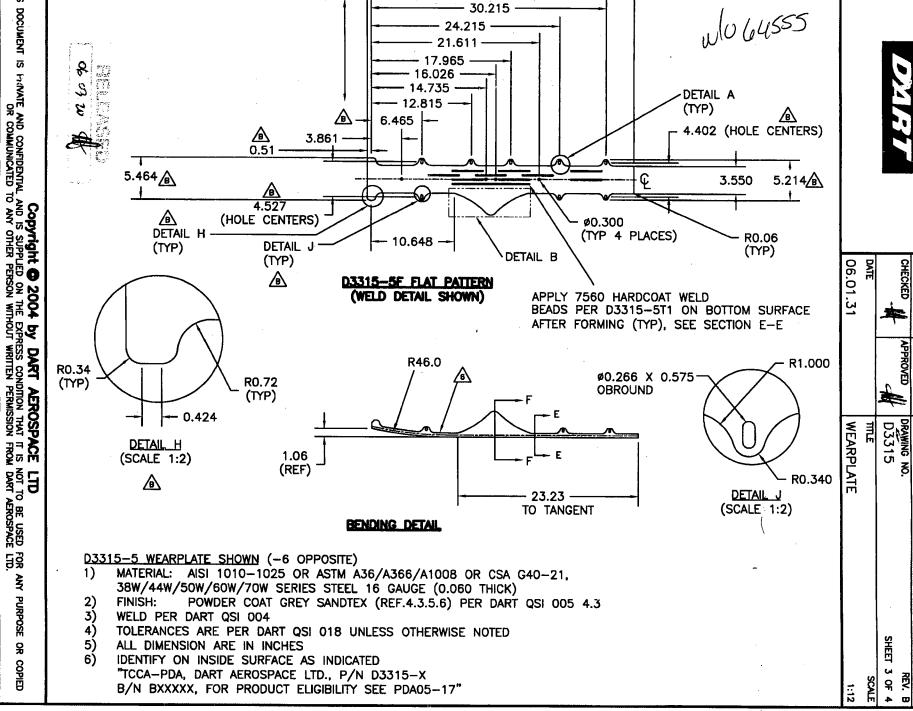
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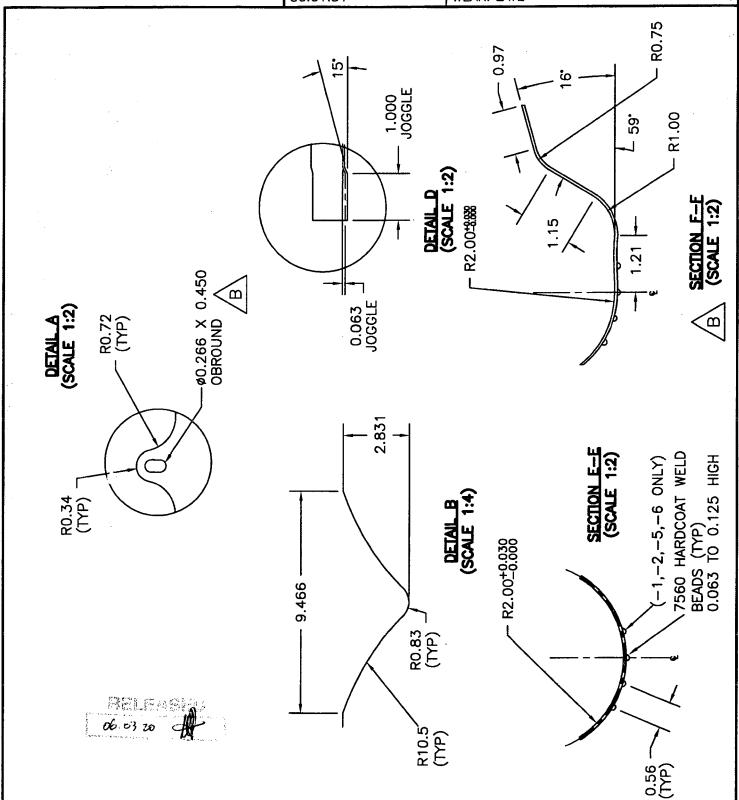
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DESIGN PH	drawn by PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED ,	APPROVED ,	DRAWING NO.	REV. B		
	#	D3315	SHEET 4 OF 4		
DATE		TITLE	SCALE		
06.01.31		WEARPLATE	NTS		



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